

Date: Wednesday, 6/7/2006 11:13:07 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ROD
Job Number	: 27447		
Estimate Number	: 10745		
P.O. Number	: N/A	Part Number	: D31344
This Issue	: 6/7/2006 S.O. No. : N/A	Drawing Number	: D3134 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: D
Previous Run	: 24340	Material	: N/A
Written By	: SEE ABOVE USER & DATE	Due Date	: 6/14/2006
Checked & Approved By	: [Signature]	Qty:	4 Um: Each
Comment	: Est. A 02.11.12 New issue KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0250W049	304 SS Seamless Tubing
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Comment: Qty.: 2.3888 f(s)/Unit Total : 9.5550 f(s)  
 304 SS Seamless Tubing  
 Cut material to length as per template D3134-3/-4T1  
 Material: AISI 304/316 Annealed SS tubing 0.250OD x 0.049 wall (M304TR0.250W.049)  
 Batch: M 100839

ml 06/06/16 4

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Open both ends with Ø0.161 (#20) drill and thread both ends as per Dwg D3134  
 Deburr rod, no sharp edges.  
 Bend as per Dwg D3134 using template D3134-4T2

PTO  
ml 06/06/19 (3)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

June 21 (3)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock  
 Location: CA-9

in space door please  
ml 06/06/23

5.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL  
 Inspection Level 21

06/06/23 (3)  
ml 06/06/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
04/04/19	2	Scrap one rod Because the Tap tool broke inside the rod	AD 04/04/19	Scrap one and <u>no</u> replace maybe the machine side could make a better job	ml 06/06/19	06-06-21	AD 06-06-21	AD 06-06-21

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 06/06/23

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

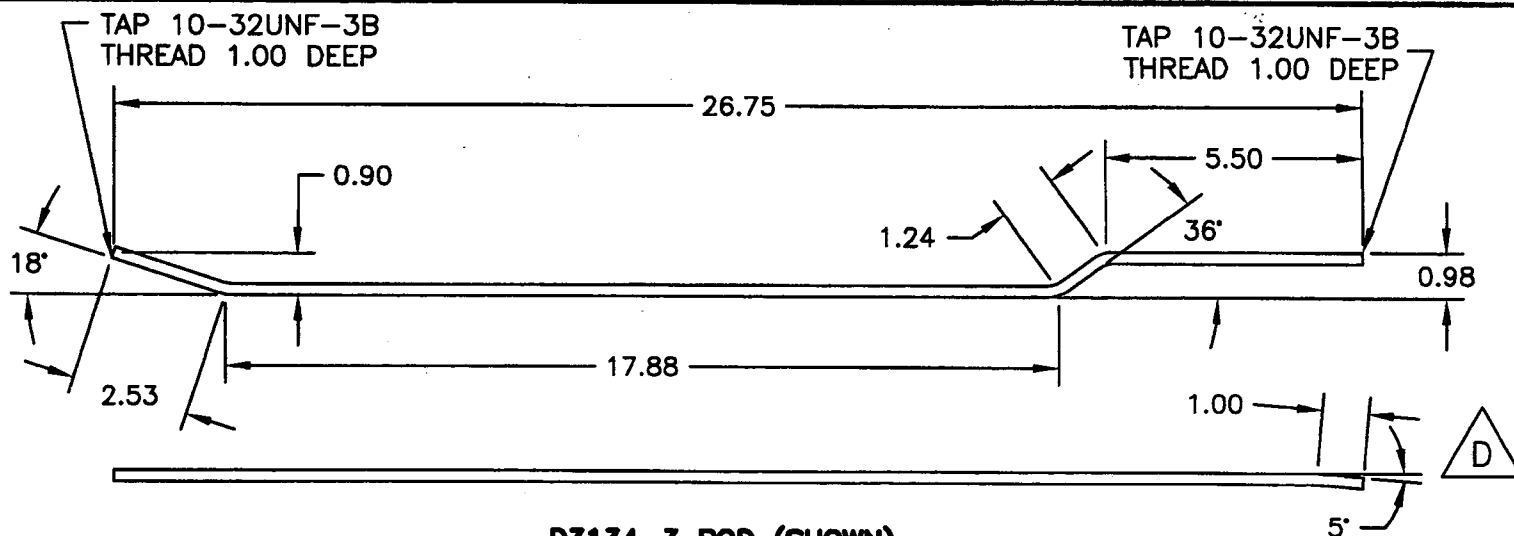
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

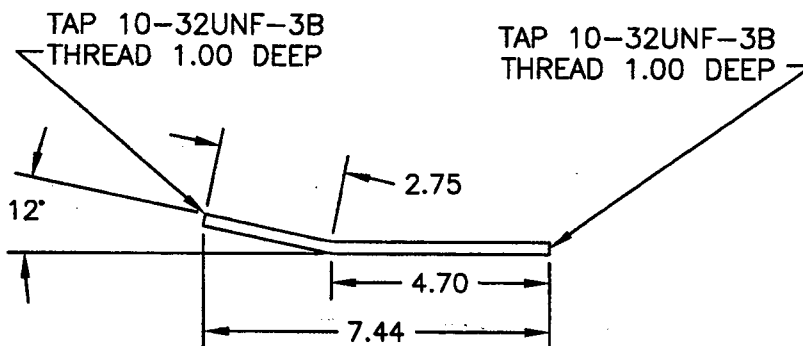
**DART**



**D3134-3 ROD (SHOWN)**

(REPLACES PREMIER P/N B30-23000-139)

**D3134-4 ROD (OPPOSITE)**



**D3134-1 ROD**

(REPLACES PREMIER P/N B30-23000-137)

RELEASE  
06-05-08  
REFERENCE ONLY

**NOTES**

- 1) MATERIAL: AISI 304/316 ANNEALED SS TUBING 0.250 OD x 0.049 WALL  
(REF DART SPEC. M304TR0.250W.049)
- 2) TOOLING: MAKE D3134-1 PER TOOL DT8656  
MAKE D3134-3 PER TOOL DT8657
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.05.08	TITLE	ROD	REV. E
		DRAWING NO.	D3134	SHEET 1 OF 2
				SCALE
				NFS
A		02.04.17	NEW ISSUE	
B		02.09.26	ADD "ANNEALED" SPEC; REDESIGNED D3134-1	
C		04.10.18	ADD PART MARKING	
D		05.12.05	CORRECT VIEW	
E		06.05.08	ADD -5, REF DSI 9331	

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

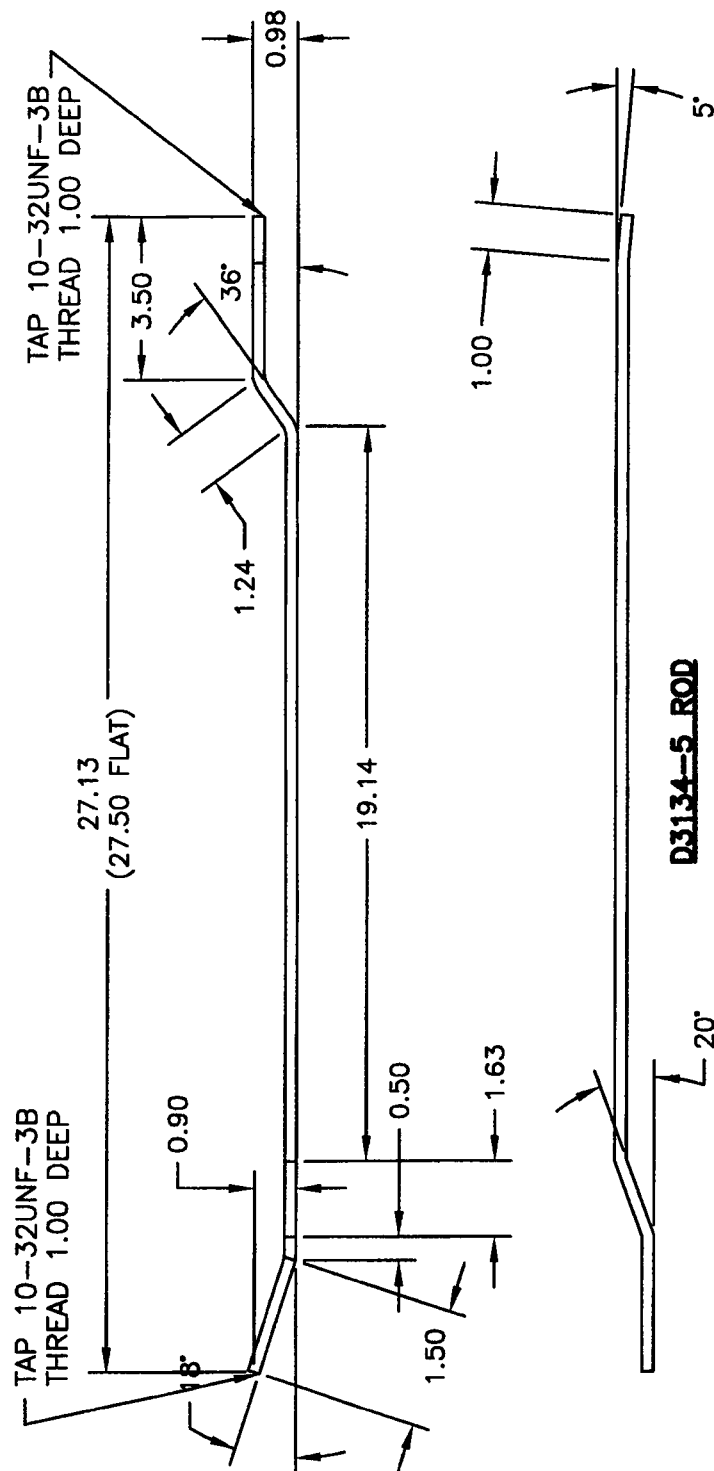
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3134	REV. E SHEET 2 OF 2
DATE 06.05.08		TITLE ROD	SCALE NTS



REFERENCE ONLY

RELEASED

06.05.09 *[Signature]*

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_